

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023886**Date Inspected:** 20-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. SHI LIE**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the bottom plate to side plate weld joint located on 13CW at cross beam side. The weld is designated as SEG3015A-012. The welder is identified as 057220. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the floor beam weld joint located on 13CW at counter weight side. The weld is designated as SEG3015H-207. The welder is identified as 066156. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair

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report number is named as WR-20901.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the floor beam to longitudinal shear plate weld joint located on 13AW. The weld is designated as SEG3013R-221. The welder is identified as 067947. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-20828.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the floor beam to I rib stiffener weld joint located on 13AW. The weld is designated as SEG3013R-213. The welder is identified as 203871. ZPMC QC Mr. SHEN JIAN BO was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-20805.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to bottom plate transverse splice weld joint located on 13AE+13BE. The weld is designated as OBE13B-003. The welder is identified as 044772. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-21047.

ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) for the deck plate to deck plate transverse splice weld joint located on 13AE+13BE at cross beam side. The weld is designated as OBE13-002.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for

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your project.

Inspected By: Pillai,Santosh

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer